

Work Order ID 67301

Tuesday, March 15, 2011 8:21:19 AM



Page 1

Item ID: D2013-3

Accept



Setup Start



Revision ID:

Item Name: Mirror Bracket LH, 212

Stop



Start Date: 3/15/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2013

Rev C

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch as per template D2013-T3 and Dwg D2013 SB 11/02/17
2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545
3-Bend (1) tube as per Dwg D2013 using Jig DT8201
Identify as D2013-3.
4-Deburr as required

m-d 11/03/18

(6)

(6X)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/03/18

(26)

-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 67301

Tuesday, March 15, 2011 8:21:20 AM



Page 2

Item ID: D2013-3

Accept



Setup Start



Revision ID:

Item Name: Mirror Bracket LH, 212

Stop



Start Date: 3/15/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: W/O

0.00



Packaging

Memo

67299

0.00

Packaging

EZ 11-3-29

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/03/29W 11-03-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 15, 2011 8:21:26 AM

Page 1

Work Order ID: 67301

Parent Item: D2013-3

Parent Item Name: Mirror Bracket LH, 212



Start Date: 3/15/2011

Required Date: 3/18/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TR0.750W.049 | | Purchased | No | | | 100 | f | 255.2314 | 1.9473 | 12.29874 | | | |
| | | | | | | | | | | | | | |
| 304 RD Tube .750 x .049W | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|-----------|----------|
| MAT | 249.61138 | |
| 108498 | 0 | |
| 110113 | 0 | |
| 115010 | 12.264255 | |
| 116720 | 3.347125 | |
| 117030 | 234 | |
| MAT014 | 0.00003 | |
| 115990 | 0.00003 | |
| MAT017 | 5.62 | |
| 109314 | 4.33 | |
| 110113 | 1.29 | |



SB 11/03/17

(6)

| W/O: | | WORK ORDER CHANGES | | | | | |
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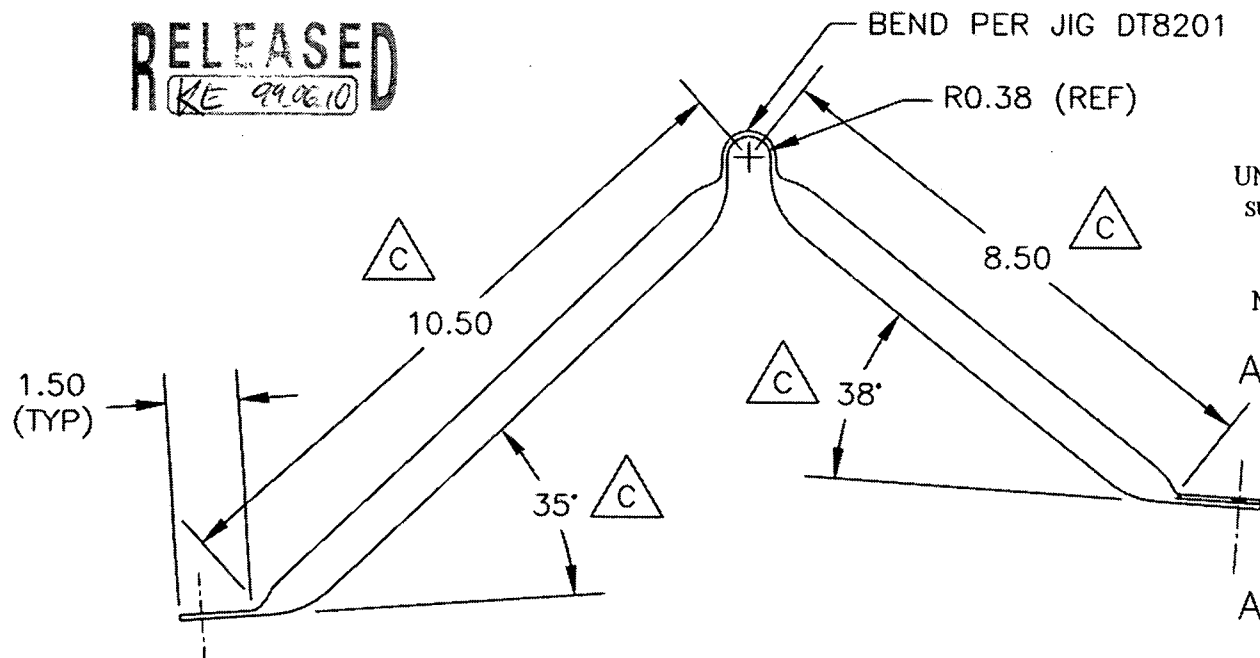
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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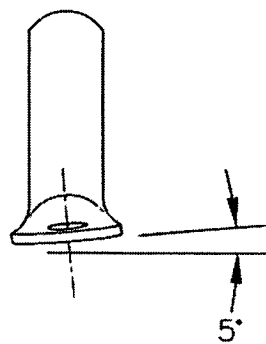
NOTE: Date & initial all entries

RELEASED
KE 99.06.10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47301
11-03-15

D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



VIEW A-A

DRILL $\phi 0.257$ (TYP)
0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DART



| DESIGN | JB | DRAWN BY | RF | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
|---------|----------|----------|-------------------------------|---|
| CHECKED | KE | APPROVED | RF | |
| DATE | 99.06.07 | TITLE | MIRROR BRACKET | REV. C |
| | | | | SHEET 1 OF 3 |
| | | | | SCALE |
| | | | | NTS |
| | A | 90.10.22 | NEW ISSUE | |
| | B | 94.06.15 | REDRAWN | |
| | C | 99.06.07 | REDRAWN, CHANGE OF DIMENSIONS | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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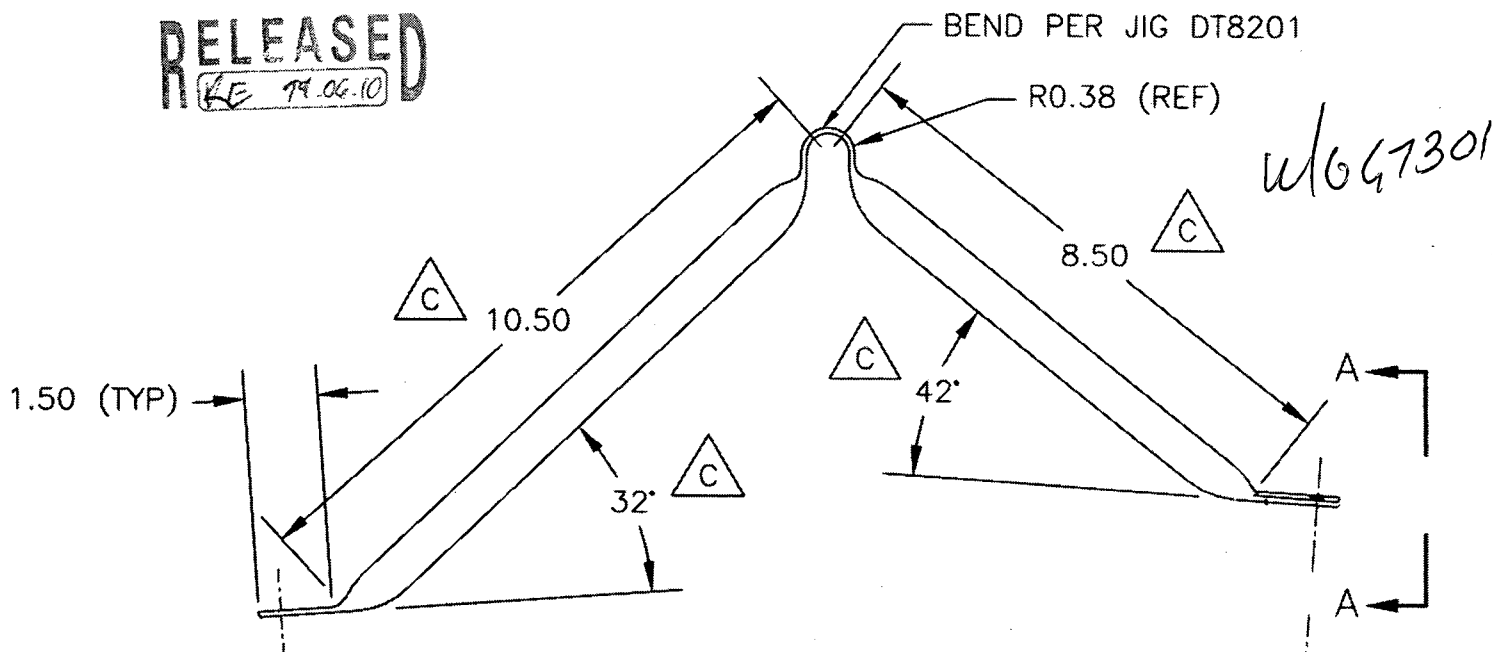
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

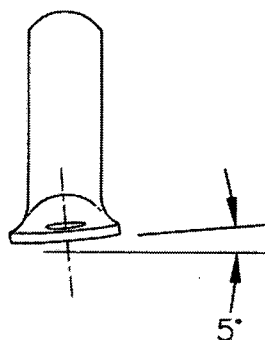
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NOTE: Date & initial all entries

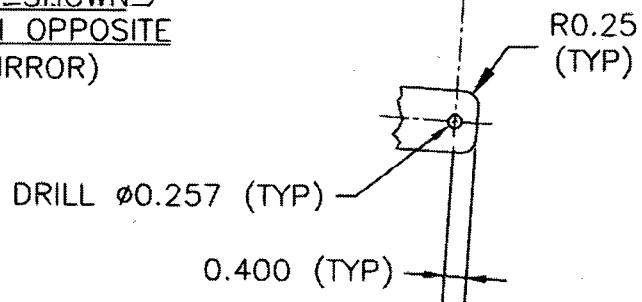
RELEASED
KE 19.06.10



D2013-3 - LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)



VIEW A-A



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DART



| | | | | |
|---------|----------|----------|----------------|---|
| DESIGN | JB | DRAWN BY | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | KE | APPROVED | [Signature] | DRAWING NO. D2013 |
| DATE | 99.06.07 | TITLE | MIRROR BRACKET | REV. C SHEET 2 OF 3 |
| | | SCALE | NTS | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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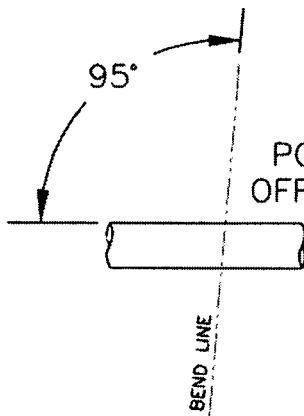
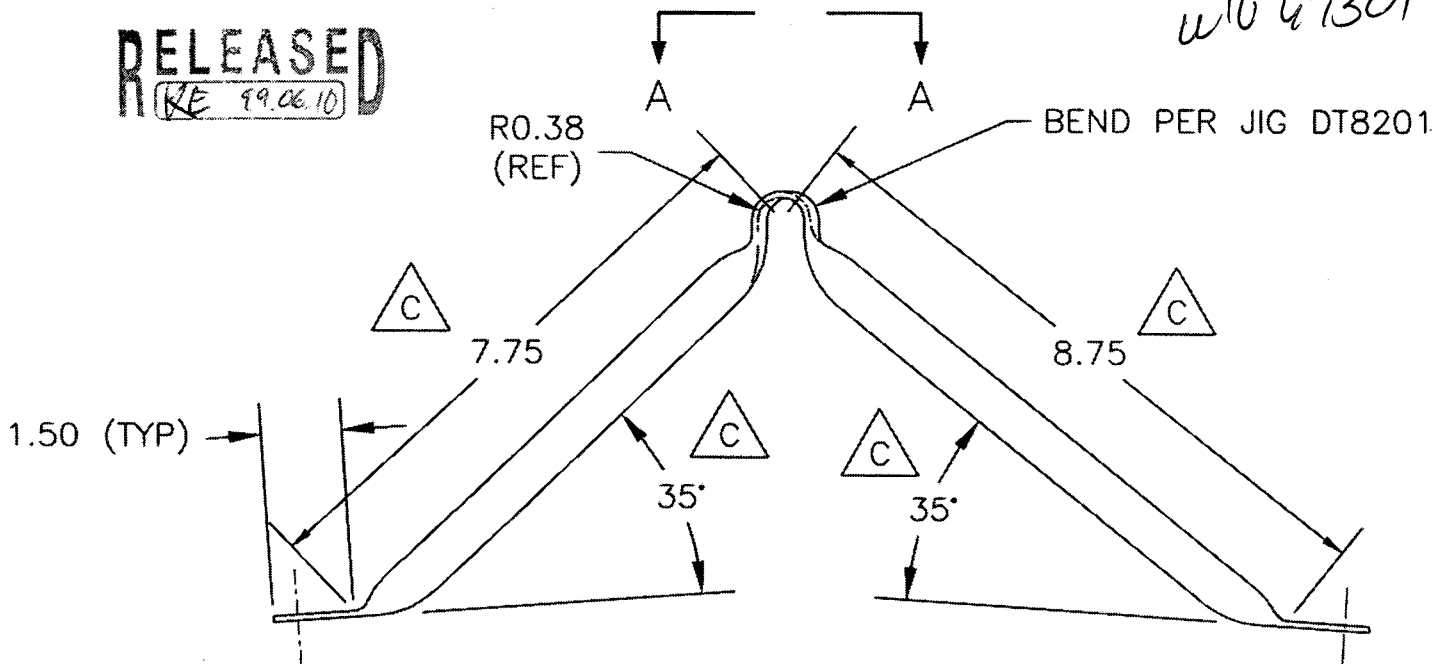
NOTE: Date & initial all entries

RELEASED
KE 99.06.10

w/6 67301

DART

QA COPY ISSUED

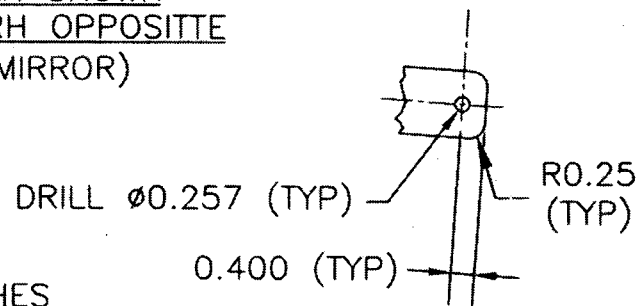


POSITION TUBE
OFFSET 5° IN JIG

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL



| | | | | | |
|---------|----------|----------|----|-------------|----------------|
| DESIGN | JB | DRAWN BY | KE | TITLE | MIRROR BRACKET |
| CHECKED | KE | APPROVED | KE | DRAWING NO. | D2013 |
| DATE | 99.06.07 | | | REV. C | SHEET 3 OF 3 |
| | | | | SCALE | NTS |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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